

# Work Order ID 53463

November 6, 2009 8:22:51 AM



Page 1

Item ID: D2574

Revision ID: E

Item Name: Saddle, Aft In 205

Start Date: 05/11/2009 Start Qty: 8.00

Required Date: 13/11/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan: *BA*

Date: *09-11-5*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. *53463* Double check by: *JS* ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

*DJP 09/12/27*

*mmf 10/01/03*

*12 0*

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2573 & D2574

*mmf 10/01/04*

*12*

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

*mmf 10/01/04*

*12*

# Work Order ID 53463

November 6, 2009 8:22:51 AM



Page 2

Item ID:	D2574	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Saddle, Aft In 205					
Start Date:	05/11/2009	Start Qty:	8.00			
Required Date:	13/11/2009	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00	LB 08/01/05			12			
QC Quality Control	Memo	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00	BR 10-01-5			(12)	4		
HandFinish Hand Finishing	Memo	0.00							
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00	7:15 AM 10-01-06			(12)	8		
Powdercoat Powder Coating	Memo	0.00							
START TIME: 7:15 AM		FINISH TIME: 7:45 AM		OVEN TEMPERATURE: 320°F					

**Work Order ID 53463**

November 6, 2009 8:22:51 AM



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Item ID: D2574

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft In 205

Start Date: 05/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

16R 10-01-06

12

1

Memo

0.00

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 434

0.00

Memo

0.00

10/01/06

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/06

MF 10-01-06

# Picklist Print

November 6, 2009 8:22:56 AM

Page 1

Work Order ID: 53463



Parent Item: D2574RevE



Parent Item Name: Saddle, Aft In 205

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005RevB		Manufactured	No			110	Each	0.0000	8.0000			
Saddle Billet												

D6101-005

B46411

X12 Billet

DJA 09/12/27

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	53463
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440				
B	1.745	1.755		1.750	1.750	1.747	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.747	1.747		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		0.499	0.503	0.503	0.501		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.5025	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.124	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.249		
S	0.115	0.135		0.128	0.128	0.130	0.130		
T	0.178	0.198		0.187	0.187	0.187	0.187		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.233	0.232	0.233	0.231		
W	0.115	0.135		0.1265	0.124	0.124	0.125		
X	0.307	0.312		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.357	0.367	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.245	0.245		
AE	1.500	1.520		1.514	1.515	1.513	1.5135		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.270	0.270	0.270	0.270		
AH	0.240	0.260		0.242	0.242	0.244	0.243		
AI	2.000	2.020		2.007	2.007	2.005	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	DJP / MME
Date:	09/12/27 / 01/01/03

Audited by:	SP
Date:	10/01/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <b>53463</b>
<b>Description:</b> Saddle, Aft Inboard		<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.497	3.498	3.496	3.497		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.003	8.005	8.001	8.003		
F	0.490	0.510		.504	.502	.502	.503		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.500	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	.566	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.124	0.124	0.124	0.123		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.250	0.249	0.249	0.252		
S	0.115	0.135		0.130	0.127	.129			
T	0.178	0.198		0.187	0.187	0.187	0.187		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.232	0.232	.232	.232		
W	0.115	0.135		.129	.121	.121	.126		
X	0.307	0.312		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.357	.355	.363	.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.625	.624	.628	.625		
AC	0.053	0.073		0.063	0.063	0.063	.063		
AD	0.240	0.260		0.244	0.243	.249	.248		
AE	1.500	1.520		1.513	1.513	1.513	1.513		
AF	0.115	0.135		0.135	0.135	.135	.135		
AG	0.240	0.280		0.270	0.270	.274	.265		
AH	0.240	0.260		0.243	0.243	.246	.246		
AI	2.000	2.020		2.005	2.004	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 09/12/28	Date: 10/01/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <u>53463</u>
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

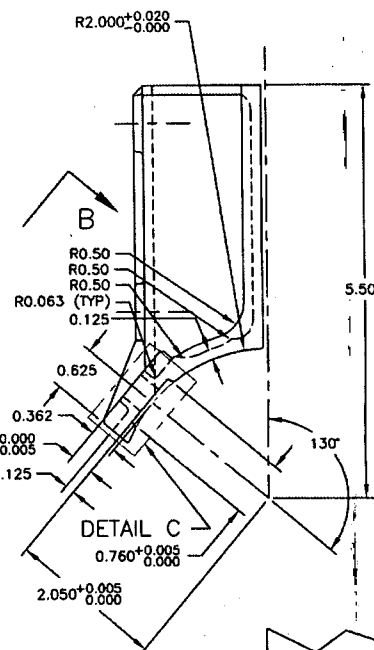
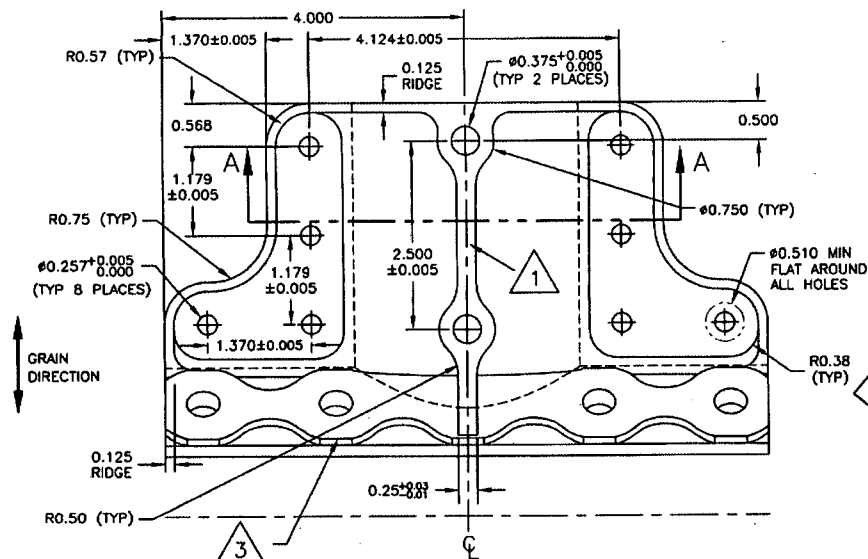
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.438	0.443		.440	.440	.440	.441		
B	1.745	1.755		1.750	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.747	1.747	1.747		
E	7.990	8.010		8.002	8.005	8.003	8.003		
F	0.490	0.510		.498	.499	.498	.499		
G	0.257	0.262		0.260	.260	.260	.260		
H	0.375	0.380		0.376	.378	.378	.377		
I	0.490	0.510		.499	.501	.502	.504		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.564	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.123	.125	.124	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.252	.252		
S	0.115	0.135		.127	.125	.121	.131		
T	0.178	0.198		0.187	.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.229	3.230		
V	0.230	0.250		.245	.236	.236	.236		
W	0.115	0.135		.130	.129	.129	.117		
X	0.307	0.312		.310	.310	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.361	.354	.358		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.513	1.513	1.514	1.514		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.276	.280	.280		
AH	0.240	0.260		.247	.246	.245	.245		
AI	2.000	2.020		2.004	2.004	2.005	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <u>DJP</u>	Audited by: <u>8/5</u>
Date: <u>09/12/31</u>	Date: <u>10/01/05</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

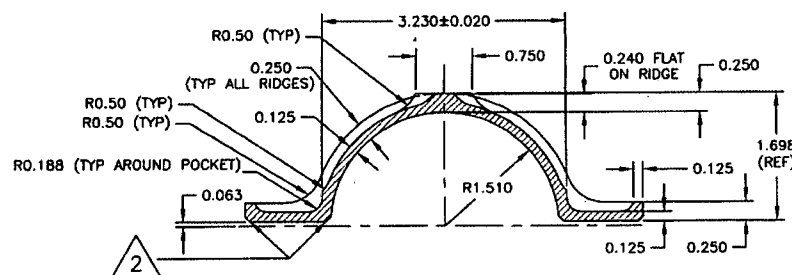
05.12.06 *ff*



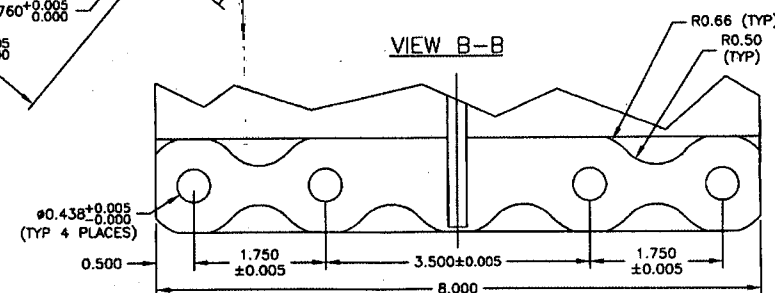
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
| 3 | CHAMFER 0.063 x 45° ALL AROUND                                   |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



SECTION A-A

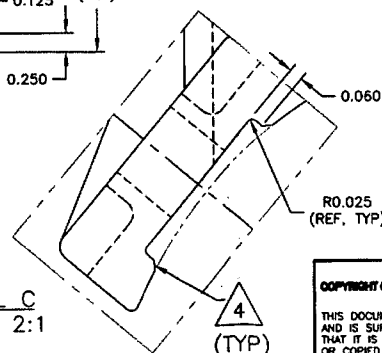


VIEW B-B

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER




NO. 53-143  
109-11-5

DETAIL C  
SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
DS	PH	
CHECKED 	APPROVED 	DRAWING NO. <b>D2574</b>
DATE	TITLE INNER AFT SADDLE	
05.07.13	REV. 1 OF 1 SHEET 1 OF 2	